

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020007**Date Inspected:** 23-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA**CWI Name:** Mr. Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG TRIAL ASSEMBLY**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**SEGMENT 12W:**

Shielded Metal Arc (SMAW) welding of Weld Joint SP3050-001-038(12BW+12CW,T Rib,CW Side), And Welder is identified as 046709; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

Flux Cored Arc (FCAW) welding of Weld Joint SP3053-001-030&SP3057-001-031(12BW+12CW,I Rib Hold back,CW Side), And Welder is identified as 053486; ZPMC Quality Control (QC) is identified as Mr. Shi Lei . The welding variables appeared to comply with the Applicable WPS-B-T-2132-ESAB.

SMAW welding of Weld Joint OBW12E-002&OBW12C-001(12BW+12CW,SP-SP&BP-BP, Holdback,CB Side), And Welder is identified as 040611; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng . The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

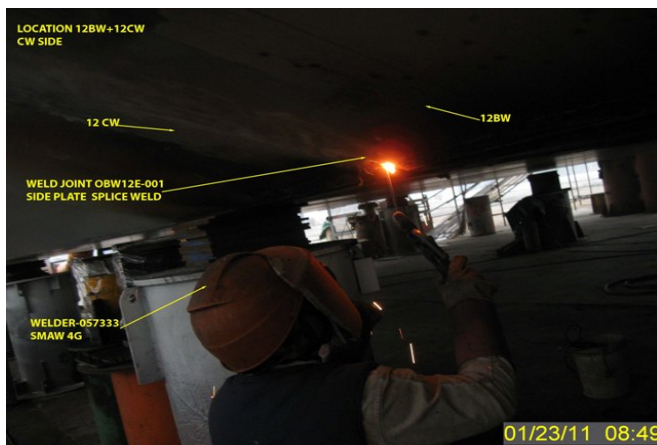
---

SMAW welding of Weld Joint OBW12E-001&OBW12C-001(12BW+12CW,SP-SP&BP-BP, Holdback,CW Side), And Welder is identified as 057333; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng . The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

### Segment 12E

SMAW welding of Weld Joint SEG3001X-051(12BE+12CE,LD-BP,BK Side), And Critical Welding Repair Report(CWR)B-CWR2760, Welder is identified as 044515; ZPMC Quality Control (QC) is identified as Mr. Liu Huajie . The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Tharikoppada,Reddy	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

---